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Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200
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D5076-045
Job Sheet 186358



006883

Part No: D5076-045

Job Qty: 2 ea

Part Name: Fwd Inboard Bracket Assembly



5135069

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5076 rev.b IPP REV:A 18.11.14 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		11/30/18	0.00	0.00	Start Up Stores/Pkg-1		Smb
110	Packaging	2 pcs		11/30/18	0.00	0.00	Packaging1-5		Smb
120	Small Fab	2 pcs		11/30/18	0.39	3.13	Small Fab-8		Smb
130	QC	2 pcs		11/30/18	0.00	0.00	QC5		38
140	Powdercoat	2 pcs		11/30/18	0.00	0.11	Powdercoat4		PL 18-10-6
150	QC	2 pcs		11/30/18	0.00	0.00	QC3		Smb
160	Small Fab	2 pcs		11/30/18	0.00	3.13	Small Fab-8		Smb
170	QC	2 pcs		11/30/18	0.00	0.00	QC5		SB
180	Packaging	2 pcs		11/30/18	0.00	0.00	Packaging3-2		88 18/12/18
190	QC21-SA	2 Ea		11/30/18	0.00	0.00	QC21		DEC 07 2018

Part Op 120 - 1-Assemble as per dwg, do not install grommets and rubber seal. ***Torque screws as per dwg note ***
Descriptions: 140 - *** MASK NUT PLATE HOLES PER DWG *** START TIME: 10.05 OVEN TEMPERATURE: 320
FINISH TIME: 10.05 M 138839
160 - Install rubber seals and grommets. Cut D4441-1 Rubber Seal to given length. - Cut qty 1 to 4.2" - Cut qty 2 to 2.6" -
Cut qty 1 to 6.7" - Cut qty 1 to 6.4" - Cut qty 1 to 9.4" 3M 1300 batch: 5092167

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5076-1	Bracket <u>613</u>	2 Ea (1 ea)	90-Start up Operation	<u>5078569</u>
D5076-3	Bracket <u>614</u>	2 Ea (1 ea)	90-Start up Operation	<u>5077423</u>
MS20426AD3-3	Rivet	28 Ea (14 ea)	90-Start up Operation	<u>5018533</u>
MS20470AD4-3	Rivet, Universal Head	30 Ea (15 ea)	90-Start up Operation	<u>5080039</u>
MS21075L08	Anchor Nut	14 Ea (7 ea)	90-Start up Operation	<u>5123462</u>
D5076-5	Bracket	2 Ea (1 ea)	90-Start up Operation	<u>5129318</u>
AN525-832R6	Screw	6 Ea (3 ea)	160-Small Fab	<u>5077415</u>
D4435-041	Bracket Assembly	2 Ea (1 ea)	160-Small Fab	<u>5117014</u>
D4440-1	Grommet	2 Ea (1 ea)	160-Small Fab	<u>5113798</u>
D4441-1	Rubber Seal	5.2920 ft (2.646 ea)	160-Small Fab	<u>5092167</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5076-1	2	6	0
	D5076-3	2	6	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

160-Small Fab

D5076-5	2	0	0
MS20426AD3-3	28	3,628	0
MS20470AD4-3	30	4,849	0
MS21075L08	14	77	0
AN525-832R6	6	78	0
D4435-041	2	11	0
D4440-1	2	14	0
D4441-1	5	539	0

Part Specifications

Specifications could not be found.

Plex 11/14/18 1:42 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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1270 Aberdeen Street Hewesbury, ON K8A 1K7 CANADA TEL: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 12/06/18 Instructions: Various STC's Revision: B Inspector: Exp Date: Container No: S135069 Part: D5076 - 045 Job No: 186358 Serial No/Batch: S135069																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					